

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011324**Date Inspected:** 15-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CWI Inspector: Mr. Liu Fu Wen

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG BAY 5

This QA Inspector observed ZPMC welder Mr. Wang Guilin, stencil 067275, is using flux cored welding procedure WPS-B-T-2132 to make traveler rail weld 10TR1-004-014. This QA Inspector observed a welding current of approximately 300 amps 32.0 volts and Mr. Wang Guilin appears to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Liu Qing Tian, stencil 066359, is using flux cored welding procedure WPS-B-T-2132 to make traveler rail weld 10TR6-001-014. This QA Inspector observed a welding current of approximately 325 amps 31.6 volts and Mr. Liu Qing Tian appears to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Jiang Min Quan, stencil 215185, is using flux cored welding procedure WPS-B-T-2132 to make traveler rail weld 10TR1-004-014. This QA Inspector observed a welding

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current of approximately 310 amps 32.0 volts and Mr. Wang Guilin appears to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Si Gao Feng, stencil 204342, is using flux cored welding procedure WPS-B-T-2132 to make traveler rail weld 10TR3-001-014. This QA Inspector observed a welding current of approximately 325 amps 31.5 volts and Mr. Si Gao Feng is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

ZPMC issued "Inspection Notification Sheet" number 4866 informing QA that ZPMC has completed ultrasonic inspections of OBG bottom plate welds BP3002-001-012 and BP3002-001-017. This QA Inspector observed ZPMC QC personnel had previously marked these welds as being ultrasonically accepted and this QA Inspector performed ultrasonic inspections of approximately 50 percent length of both of these welds. Items observed by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on these inspections see the TL6027 Ultrasonic Test Report dated today.

Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
